

Date: Thursday, 20/11/2008 3:32:41 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 43587	
Estimate Number : 11968	
P.O. Number :	Part Number : D2061
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D2061 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 30161	Material :
Written By :	Due Date : 20/12/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 08.11.21</u>	
Comment : Est: B 01.12.17 Added step 3, 4 and Inspection Level 21. SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: 7655

Make per Dwg D2061

Possible Supplier: Sieg's Manufacturing

Material release note required

C208111124(20)

2.0

D2061P

Aspirator

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

ASPIRATOR BODY

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receieve & Inspect for Transit Damage

Ensure Material Release Note is attached

R 8/14/11 (20)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECKS 08/12/12 (20) center

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr and clean to remove was residue

a 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:32:41 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 43587

Part Number: D2061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/12 (red)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

GA.

MF 09-02-12

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/12 JF

Job Completion



MF 09-02-12

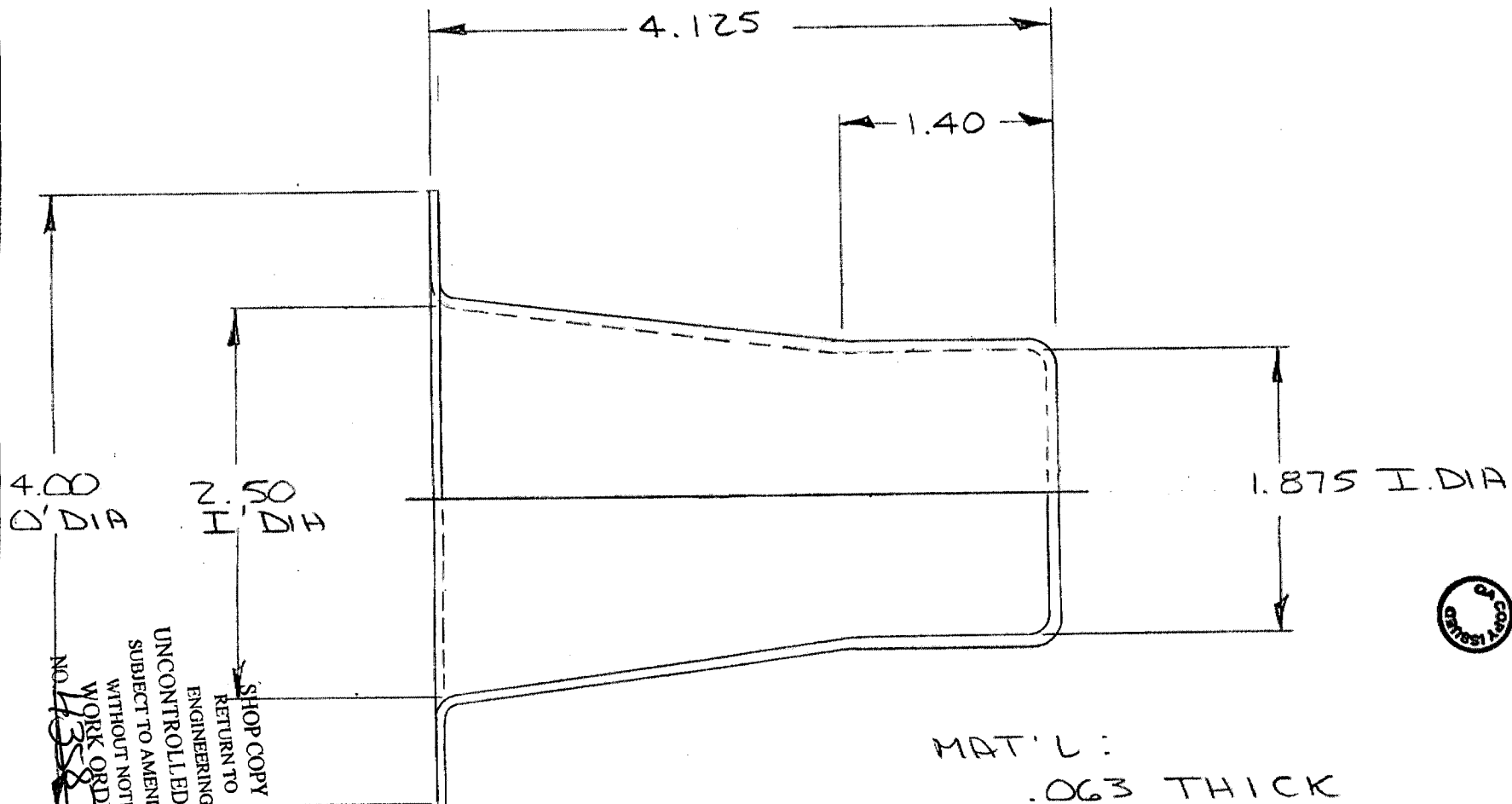
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MAT'L :
 .063 THICK
 1100 ALUMINUM

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 43587

REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER MAS 523		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC./VENDOR	
DRAWN				BASIC CODE		CONTRACT NO.		DRAWN		DATE		DART AERO ACCESSORIES INC.		VANCOUVER CANADA	
APPROVED				D-DIMPLE DIGIT=NO OF SHEETS C-COUNTERSINK		LENGTH DASH NO. WP=SPOTWELD		DESIGN		1992					
DESCRIPTION OF CHANGE		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		STRESS		CHECKED		CLIENT		TITLE		REV.	
		GENERAL		LIMITS		B=MAS20470AD BB=MAS20426AD						ASPIRATOR BODY			
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 / 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH — S — 7242 5. HOLES PER AND 10387		1. TOLERANCES — .001 & .030 2. ANGLES .001 & .010 3. PARALLELISM & .0025 4. ECCENTRICITY & .005 MAX. 5. SYMMETRY ABOUT ALL MFC CENTRE LINES .005								CODE		DNG NO.	
												YSD 2061		1	
												SCALE		1:1	
												SHT		OF 1	

REPORT ALL DISCREPANCIES — DO NOT SCALE

A

YSD 2061



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: 12/10/08

Customer: Dart Aerospace

Packing Slip: 36124

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2000109S	10	14G	✓	✓	12/10/08
D2000111S	10	14G.	✓	✓	12/10/08
D2060S	20	14G	✓	✓	12/10/08
D2061P	20	14G	n/a	✓	12/10/08

Notes:

PO# 7655

12/14/11

Material Certification Attached: Yes ~~NO~~

WFM GERRY



ALCOA INM PRODUCTS
1480 Manheim Pike
Lancaster Pa 17601

Certification of Test Results

P/N 970200

PO 380880

SOLD TO

SHIP TO

CERT NO 3000675996
DATE 4/23/2007
SKID NO 661033
SKID WGT 9,885
PAGE 1 OF 1

ORDER NO	LG5947	PO NO	43-62756			MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO				
ALLOY	1100	TEMPER	O	FORM	COIL	
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 334171 COIL: 801 DROP: 07T0187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*U718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 C, AMS 4001H 1100 O,
ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O
PRX CERTS: 714-736-4840

** END OF CERTIFICATION **

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

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Authorized By:

JEFF KREADY, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 380880 Part: Order No.: 376276
TR clerk signature: *C. Kready*